

Work Order ID 57943

April 21, 2010 8:40:45 AM



Page 1

Item ID: D3535-25

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 21/04/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

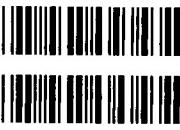
PL

Date: 16-4-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D3535	Rev B								
-------	-------	--	--	--	--	--	--	--	--

100 FLOW WATER JET



Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

HB 10-5-5

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

HB 10-5-5

120



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

S wlostos

(FB)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 57943

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Page 2

Item ID: D3535-25

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID
130

Brake NC

Brake NC

Operation
Description
NC BRAKESet Up/
Run Hours
0.00Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/05/06

+12

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112589

0.00

=> M 10/05/10

13

g

START TIME: 1:00pm OVEN TEMPERATURE:
1:20pm FINISH TIME: 326°C

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 3

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Setup Start



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Stop



Start Date: 21/04/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



QC

QC3- Inspect Part Finish

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

13

BL 10-5-10

Quality Control

170

Packaging
Packaging

Identify as per dwg & Stock Location: FP-18

0.00

M 10/05/10

13

d

180



Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/12 JJ
~~10/05/10~~

MF 10-5-10

W/O:

WORK ORDER CHANGES

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NOTE: Date & initial all entries

Picklist Print

April 21, 2010 8:40:49 AM

Page 1

Work Order ID: 57943



Parent Item: D3535-25



Parent Item Name: Wearshoe

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:A New Issue 07-02-15 JLM

Start Qty: 12.00

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA			No			100	sf	36.9800	6.4421			

304/316 .040 Sheet

IB 10-5-5

Warehouse

Location

Main Warehouse

MAT20	36.98
112885	5
113062	31.98

114574

Loc Qty

Loc Code

114574

165

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	57943
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	RB	Audited by:	<u>E</u>	Prototype Approval:	N/A
Date:	10-5-15	Date:	10/05/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

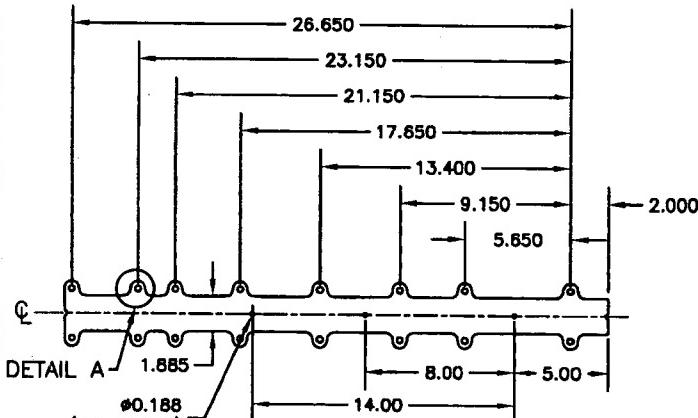
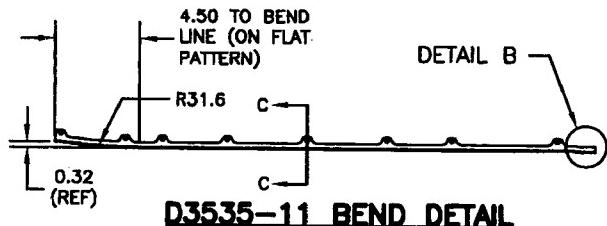
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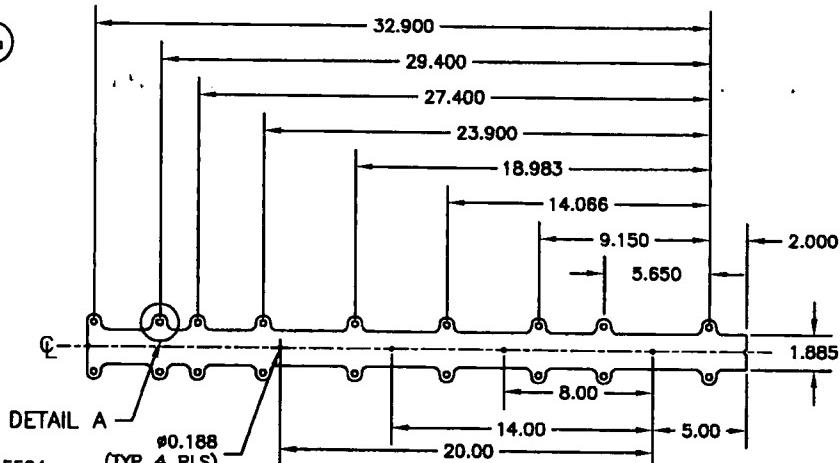
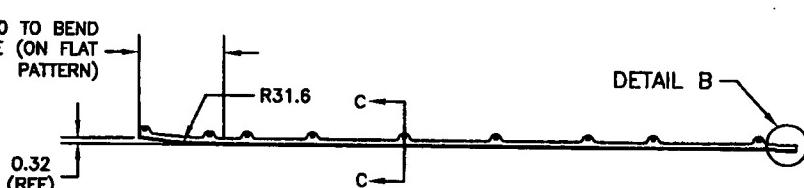
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NOTE: Date & initial all entries

DART**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57943
BS 10-11-21

RELEASED57.04.24 *[Signature]***D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

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- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
DATE		TITLE	SCALE
07.04.17	<i>[Signature]</i>	D3535	1:10
A	06.10.25	WEARSHOE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

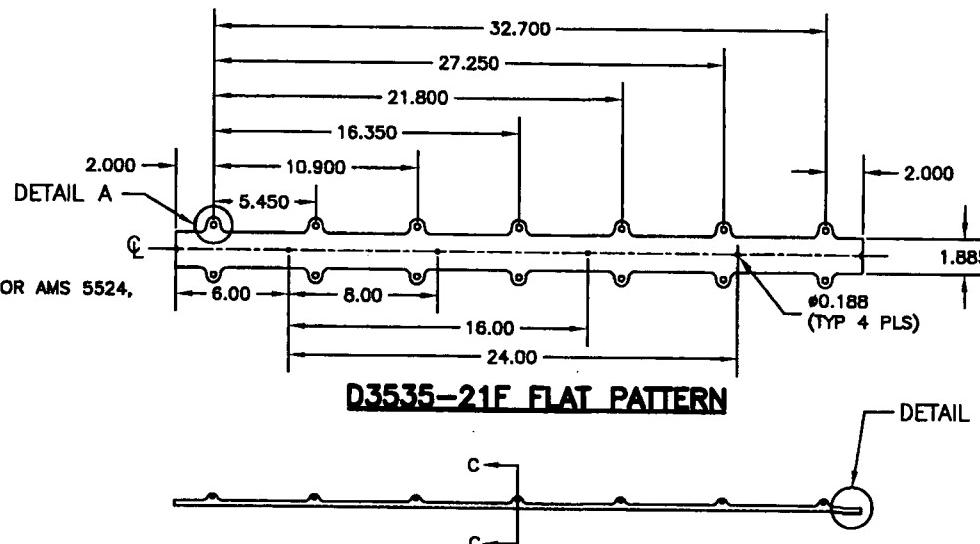
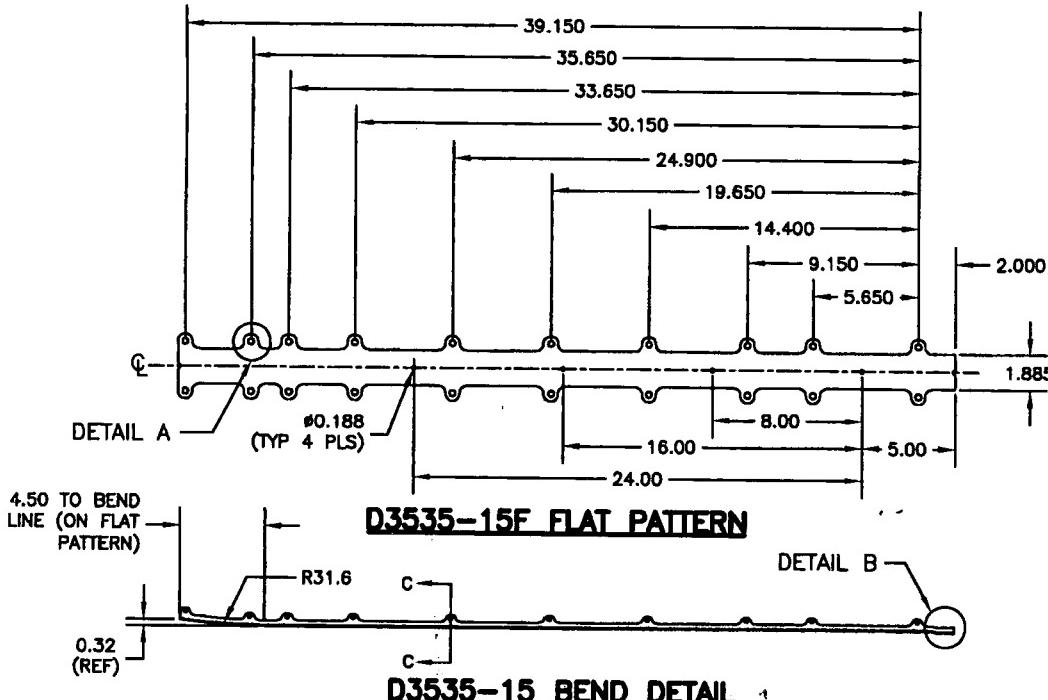
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NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY M	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED #	APPROVED #	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 2 OF 7 SCALE 1:10

RELEASED
07.04.24 **#***W0 57943***NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
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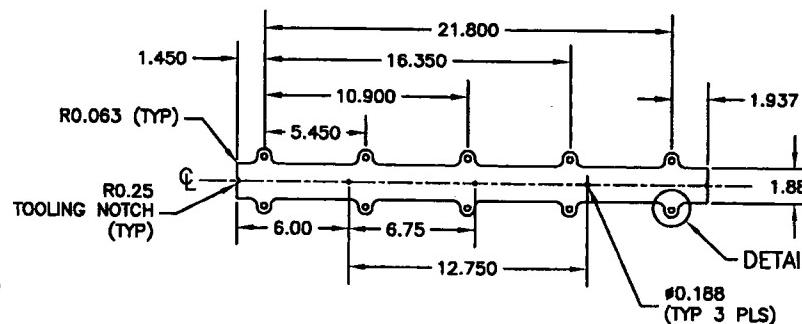
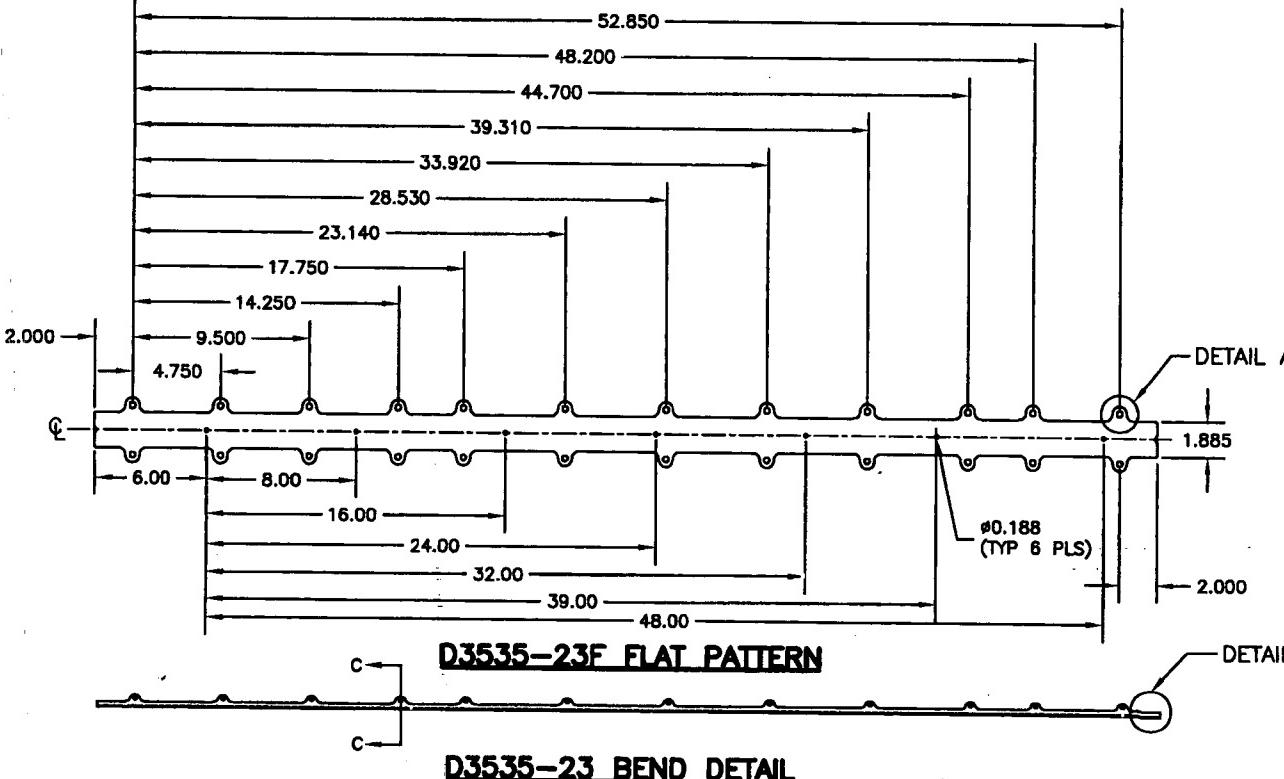
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN CB	DRAWN BY MH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED MH	APPROVED MH	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE
		SCALE 1:10

RELEASED
07.04.24
*MH**w10 57943***NOTES**

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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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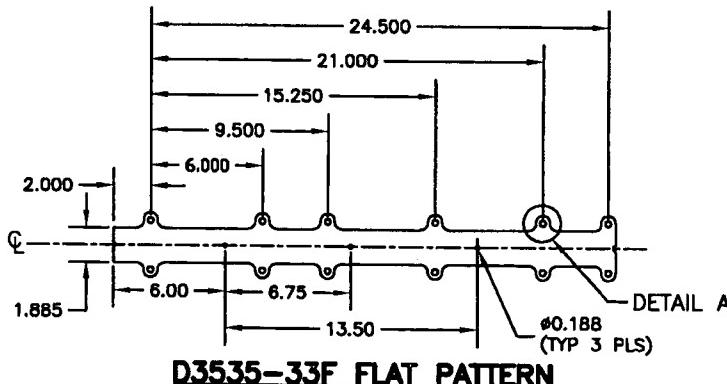
NOTE: Date & initial all entries

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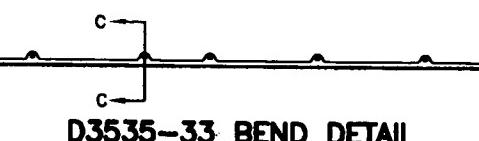
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CHECKED MH	APPROVED MH	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 4 OF 7 SCALE 1:10

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07.04.17

w/o 57943



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
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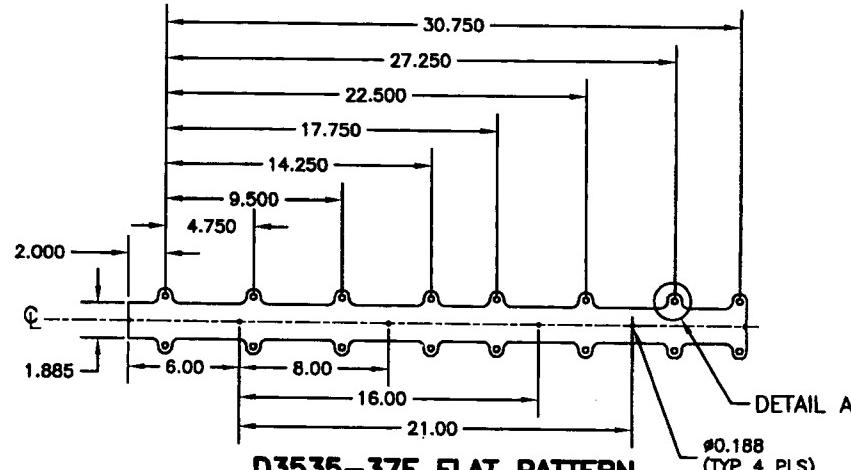
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CHECKED MH	APPROVED MH	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE

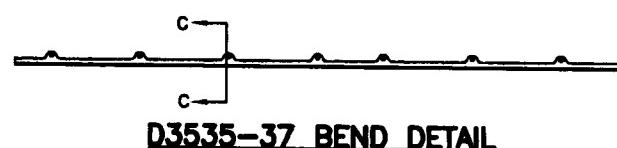
REV. B
SHEET 5 OF 7
SCALE 1:10

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07.04.17

w/o 57943



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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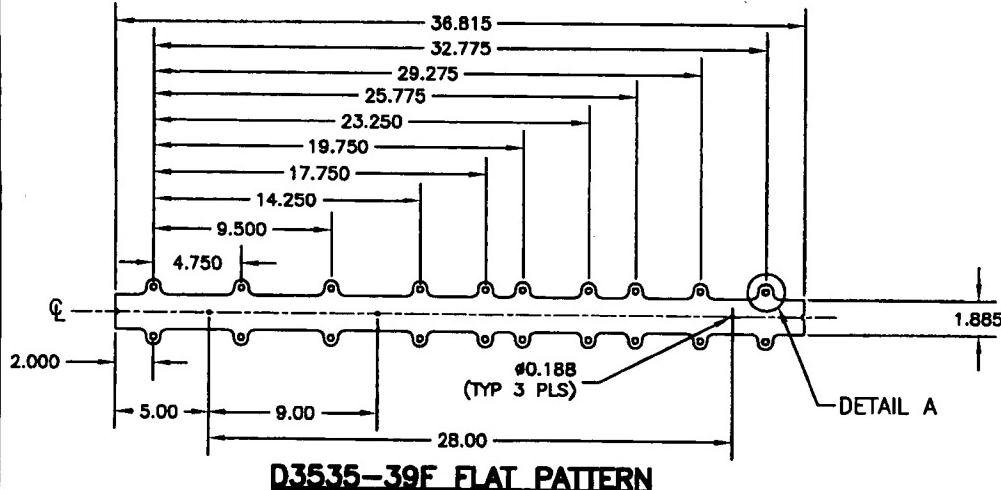
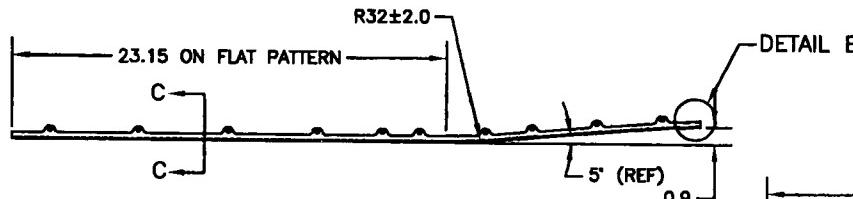
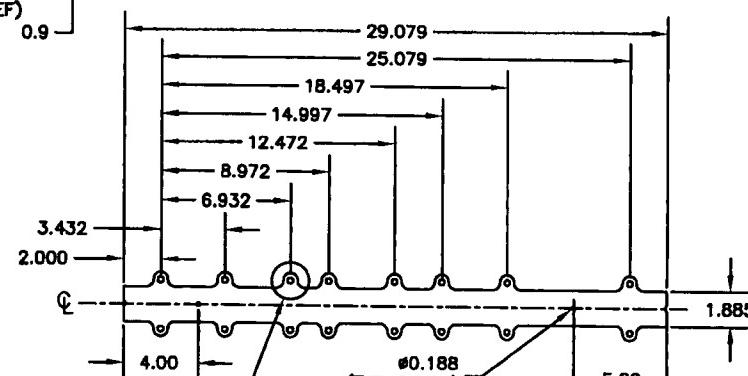
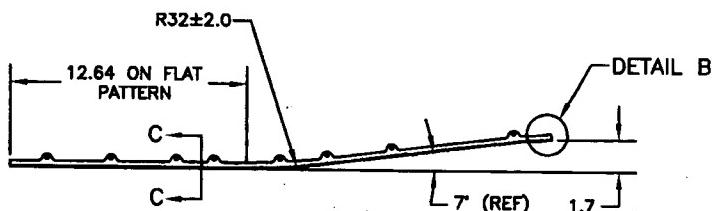
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CHECKED /	APPROVED /	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 6 OF 7 SCALE 1:10

RELEASED
07-04-17

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

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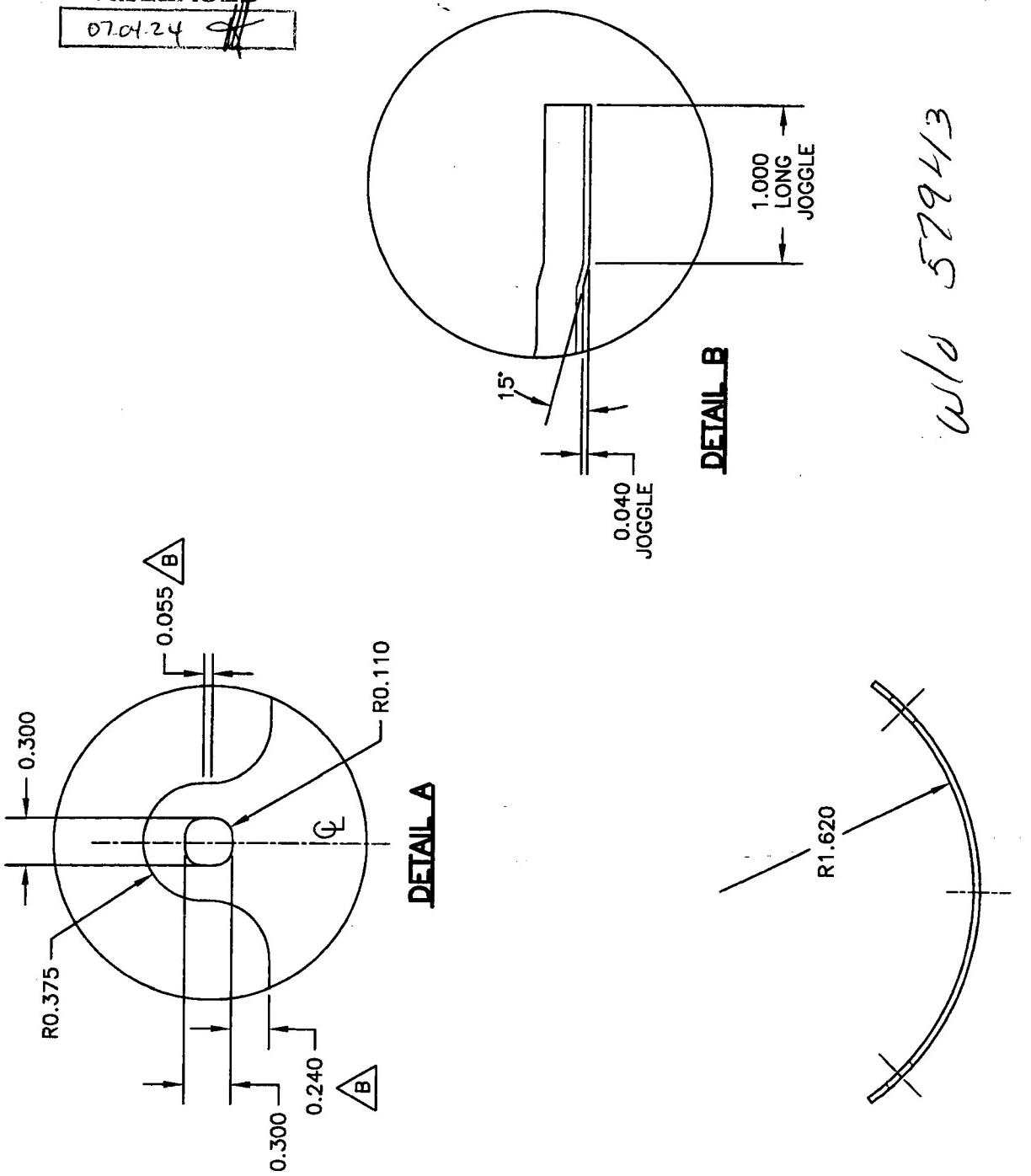
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RELEASED

07.04.24 ~~✓~~

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